

Date: Thursday, 2/1/2007 2:49:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HEATER EXTERIOR SHEET
Job Number	: 30579		
Estimate Number	: 12691		
P.O. Number	: N/A	Part Number	: D2295
This Issue	: 2/1/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2295 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	:	Drawing Revision	: B
		Material	: N/A
Written By	:	Due Date	: 3/15/2007
Checked & Approved By	:	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S032	6061-T6 Sheet 0.032"
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Comment: Qty.: 2.6250 sf(s)/Unit Total: 10.5000 sf(s)

6061-T6 Sheet 0.032"

Batch: M18375

FF 07-03-06

4

2.0	WATER JET SMALL FAB.	FLOW WATER JET
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Comment: ~~FLOW WATER JET~~
 1 set as per Dwg D2295

Dwg Rev.

Prog Rev.

2-DRILL AS PER Template T2295 D5.

3-Deburr if necessary

FF 07-03-08

4

3.0	QCS	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/03/12 (4)

4.0	QCS	SECOND CHECK
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N/A



Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

04/03/13 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: HEATER EXTERIOR SHEET

Job Number: 30579

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2007/03/17

Job Completion



u 07-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

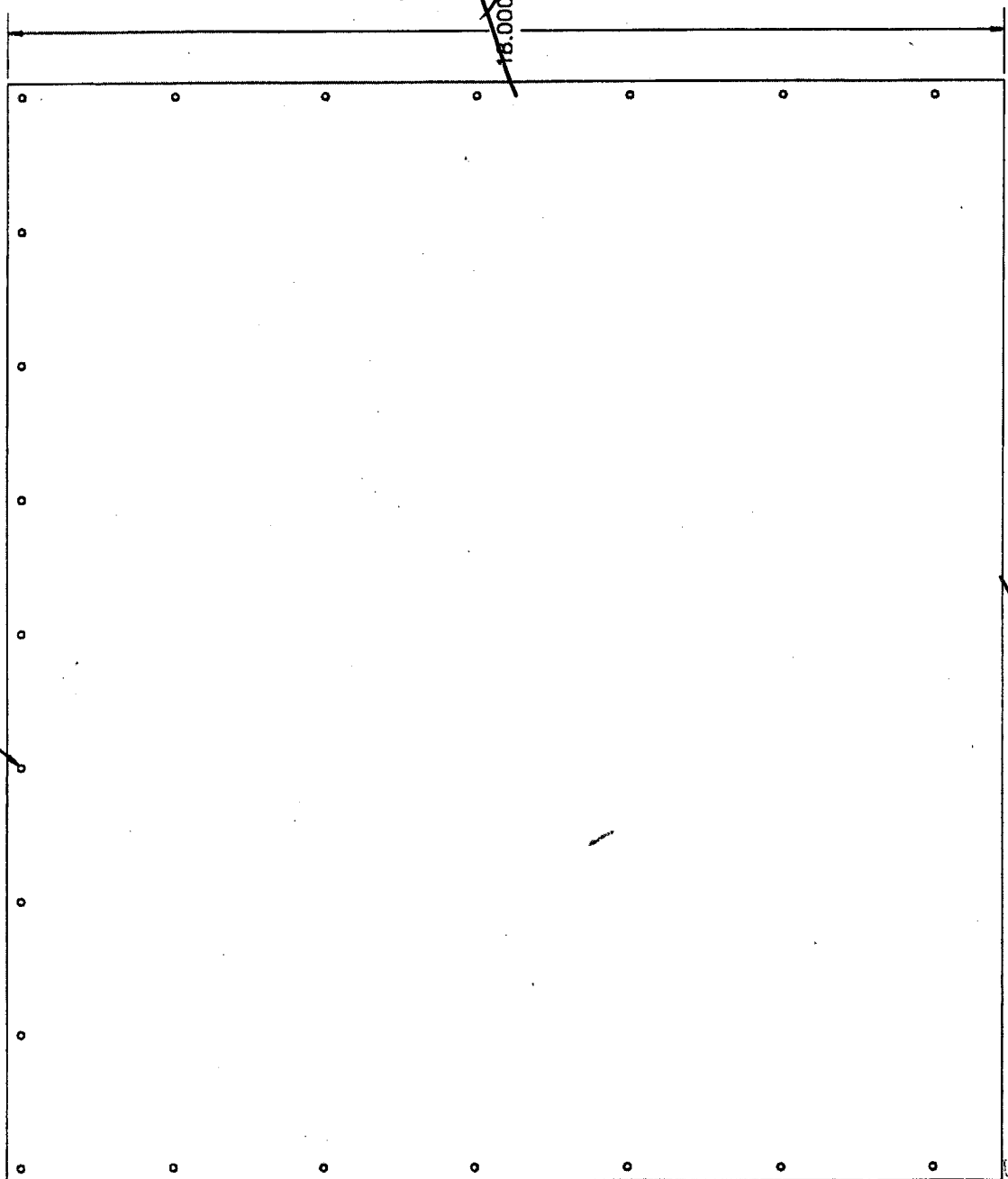
NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2295	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE HEATER EXTERIOR SHEET	SCALE 1:3
B	96.01.15	DEFINE HOLES	

20.000
18.000
07.03.12

Ø0.128 DRILL PER TEMPLATE T2295DJ



07.03.12
18.000
MATERIAL: 6061-T6 OR 5052-H34 SHEET
0.032 THICK CUT 18 X 20

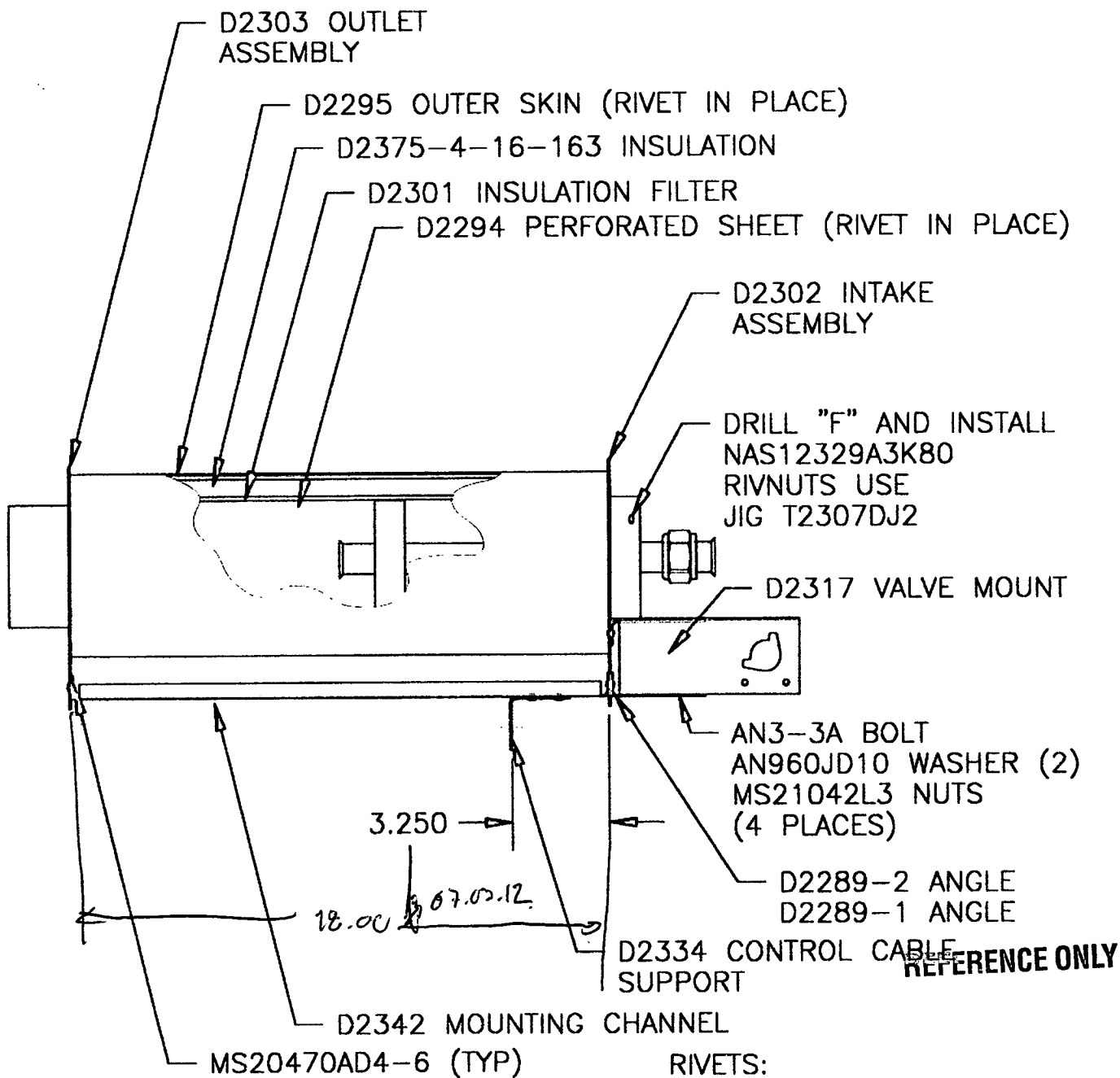
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30579*



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2306	REV. C SHEET 1 OF 2
DATE 95.01.03		TITLE B204 ASPIRATOR ASSEMBLY	
B	Apr. 13, 1995	REVISED D2317	
C	96.01.19	ADDED DETAIL	

QTY	Part No.	Description
X	D2306	B204 ASPIRATOR ASSEMBLY
1	D2302	INTAKE WELDMENT ASSEMBLY
1	D2303	OUTLET WELDMENT ASSEMBLY
1	D2295	HEATER EXTERIOR SHEET
1	D2375-4-16-163	INSULATION
1	D2301	INSULATION FILTER
1	D2294	HEATER PERFORATED SHEET
1	D2289-1	VALVE MOUNTING BRACKET
1	D2289-2	VALVE MOUNTING BRACKET
1	D2317	VALVE MOUNTING BRACKET
1	D2334	CONTROL CABLE SUPPORT
1	D2342	MOUNTING CHANNEL
4	AN3-3A	BOLT
8	AN960JD10	WASHER
7	MS20600AD4W5	RIVETS CR9163-4-2
23	MS20600AD4W6	RIVETS CR9163-4-4
6	MS20470AD4-6	RIVETS
4	MS21042L3	NUTS
2	NAS1329A3K80	RIVNUTS

REFERENCE ONLY

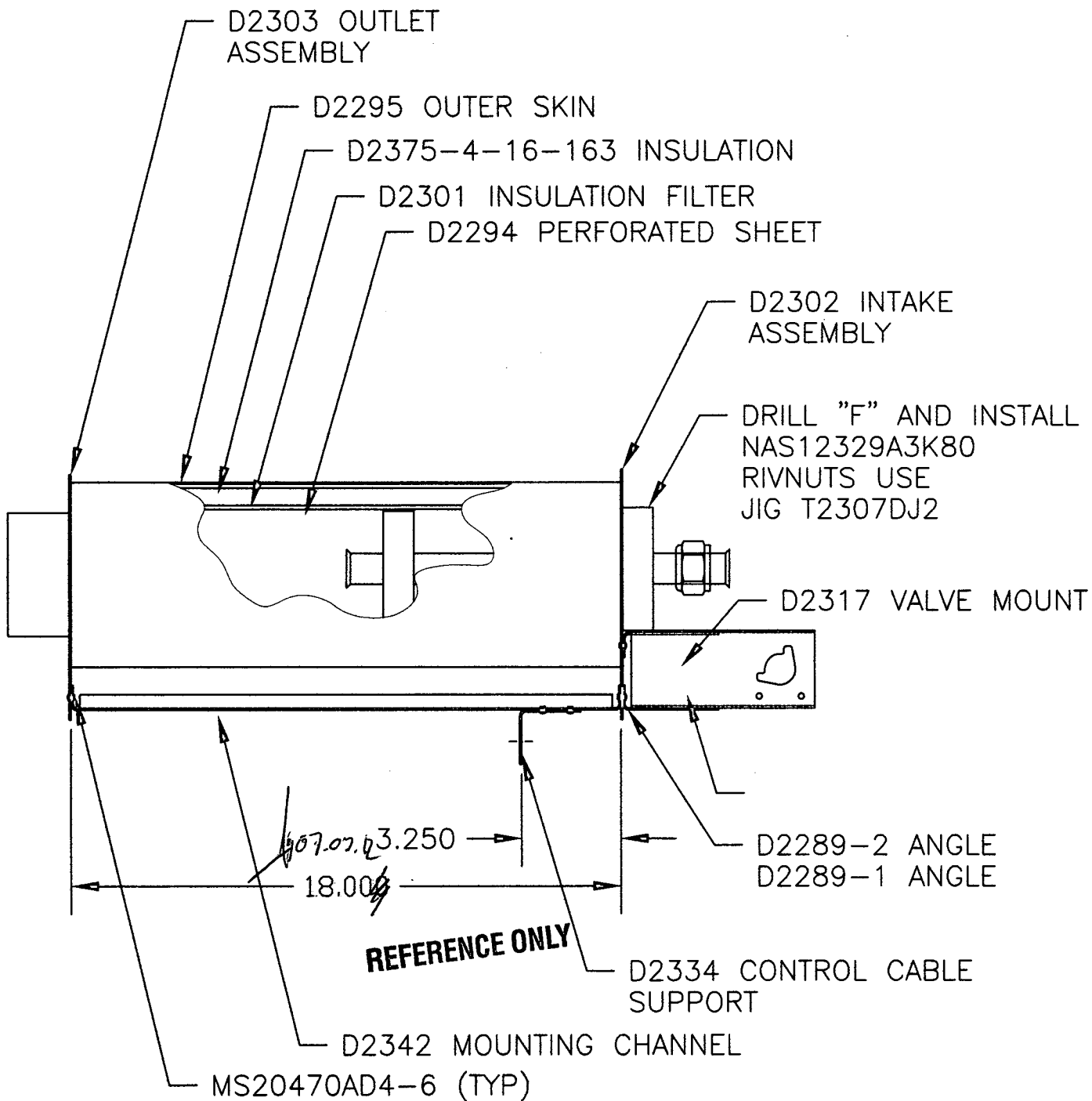


RIVETS:
MS20600AD4W5 SHEET TO SHEET
MS20600AD4W6 SHEET TO END

REFERENCE ONLY



DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	B WILLIAMS	APPROVED	B WILLIAMS	REV. C
DATE	95.01.03	TITLE	B204 ASPIRATOR ASSEMBLY	SHEET 2 OF 2
				SCALE



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C	
CHECKED	APPROVED	D2306	SHEET 2 OF 2	
DATE		TITLE	SCALE	
95.01.03		B204 ASPIRATOR ASSEMBLY		
B	Apr. 13, 1995	REVISED D2317		
C	96.01.19	ADDED DETAIL		